

Shy Aug 18 Work-Order ID 72436

Monday, July 25, 2011 2:38:53 PM



Page 1

Item ID:	D4018-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Short Basket Lid Assembly (350)					
Start Date:	7/25/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	8/8/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-07-25	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4018	C

100 Weld per dwg A/R S.S. rod Batch: 1115778 0.00
Large Fab

Large Fab Memo 0.00
1- assemble ribs , weld as per dwg D4018 using DT9607B
2- weld hinge (3) and Mounting brackets as per dwg D4018
inspect before welding mesh
3- tack weld mesh on basket as per dwg D4018
make sure to place mesh correctly on lid, check with label plate before tacking mesh

11.08.03

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC Memo 0.00

Quality Control

BE 11/08/03
11.08.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72436

Monday, July 25, 2011 2:38:53 PM



Page 2

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Lid Assembly (350)

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

8/25/04



QC

Memo

0.00

Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M115120



Powdercoat

Memo

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time: *11:30 AM*

Oven Temperature: *320°F*

Finish Time: *2:00 PM*

1/08/01

140

Wing Walk as per dwg QSI005 4.4 Batch

0.00

M118313



HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg
2- install label

1X Ø M 11/08/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72436

Monday, July 25, 2011 2:38:53 PM



Page 3

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Lid Assembly (350)

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

9/5/08/09 @

160

Identify as per dwg & Stock Location: 6-A

0.00



Packaging

Memo

0.00

Packaging

w/o
72436

9/5/08/09 @

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/10

11-08-8



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Monday, July 25, 2011 2:38:58 PM

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)




Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4018-1  Rib		Manufactured	No			100	Each	4.0000	2	2		11.07.28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				4					
				71992				1					
				71996				3					
D4018-3  Rib		Manufactured	No			100	Each	6.0000	2	2		11.07.28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				6					
				68479				6					
D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	16.0000	3	3		11.07.28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				16					
				71941				16					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 2:38:59 PM

Page 2

Work Order ID: 72436

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4018-5

Manufactured No

100

Each

34.0000

6

6



Rib

Location

Loc Qty

Loc Code

WA

23

70758

5

71939

18

WA005

11

67041

11

D4035-041

Manufactured No

100

Each

3.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)

Location

Loc Qty

Loc Code

WA

3

63720

0

71484

1

72088

2

D4035-043

Manufactured No

100

Each

0.0000

1

1



Lid Rib Assembly, Aft (350 Basket)

D2581

Manufactured No

100

Each

63.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

63

69258

28

69739

2

70766

33

Monday, July 25, 2011 2:38:59 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 2:38:59 PM

Page 3

Work Order ID: 72436

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4020-7
Manufactured No
Mesh (350 Basket Short, Lid)

100 Each 1.0000



11-08-02 371815

Location Loc Qty Loc Code

FG 1
68523 1

D4021-3
Manufactured No
Data Plate

100 Each 12.0000



11-27-28

Location Loc Qty Loc Code

WA 12
71943 12

D2728-3
Manufactured No
Dart Logo label

140 Each 0.0000



11/08/04

~~M150050~~
M115050

Monday, July 25, 2011 2:38:59 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

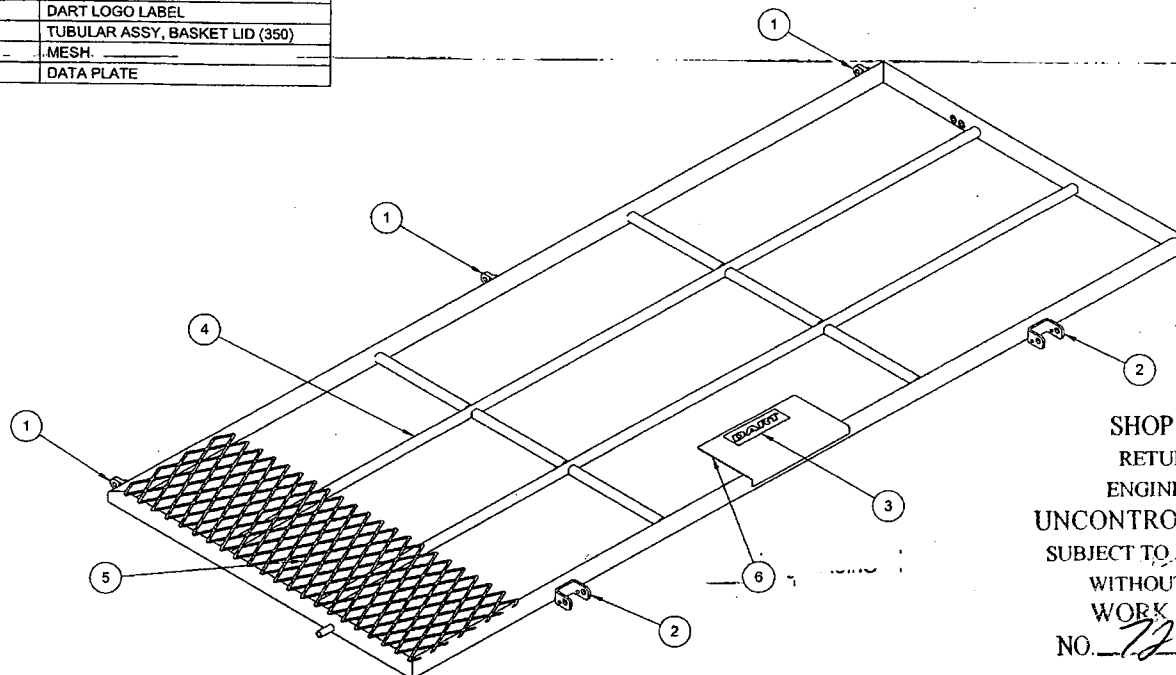
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4018-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72439

11-07-25 **RELEASED**
ECN 10-946

C	REMOVED D4088-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4088-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED	<i>SC</i>	D4018	SHEET 1 OF 4
MFG. APPR.	<i>MS</i>	TITLE	SCALE
APPROVED		SHORT BASKET LID ASSY (350)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY OTHER MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

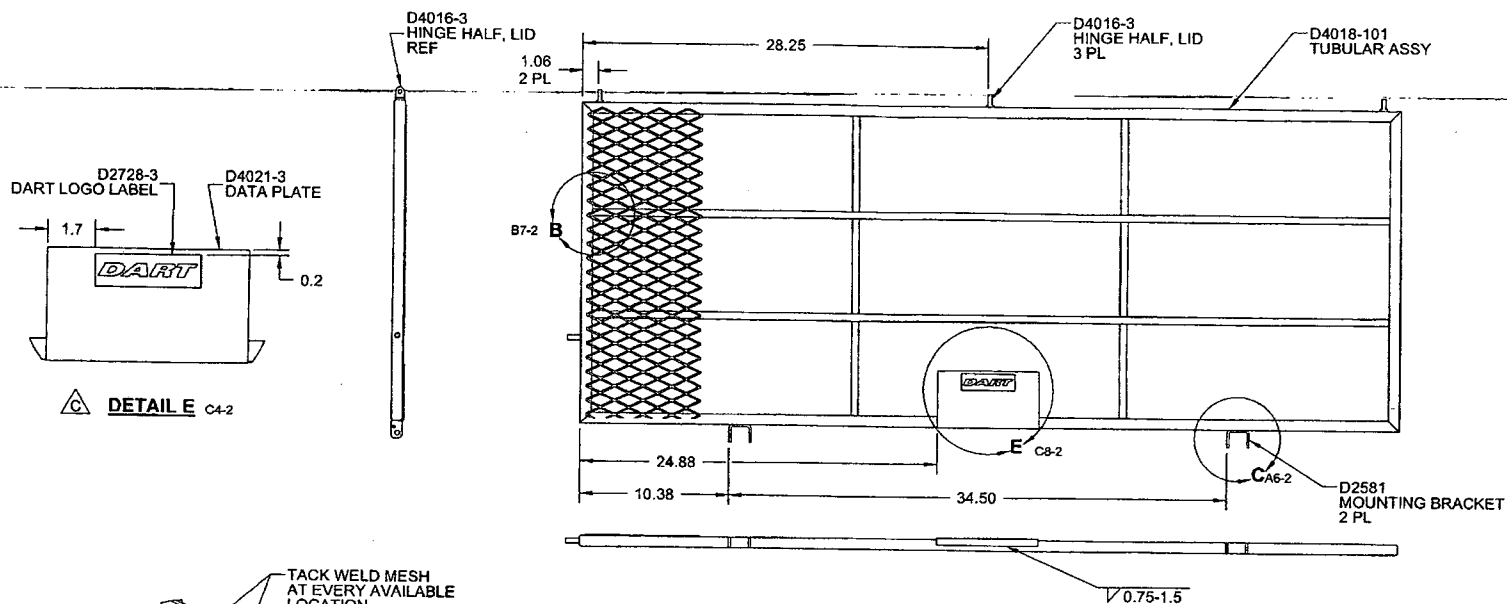
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

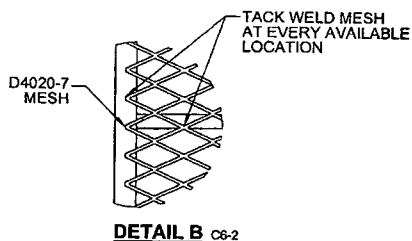
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

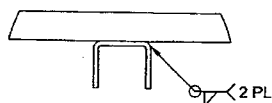
NOTE: Date & initial all entries



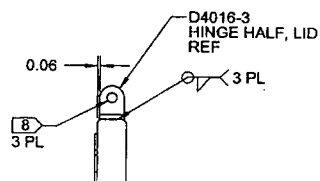
DETAIL E C4-2



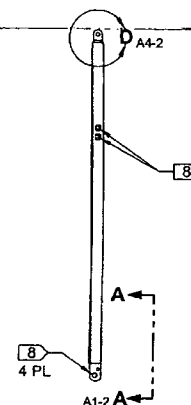
DETAIL B C6-2



DETAIL C C3-2



DETAIL D D1-2



VIEW A-A C1-2

RELEASED
10.08.12

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

72434

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 2 OF 4
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	SHORT BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ON ANY MEDIUM TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

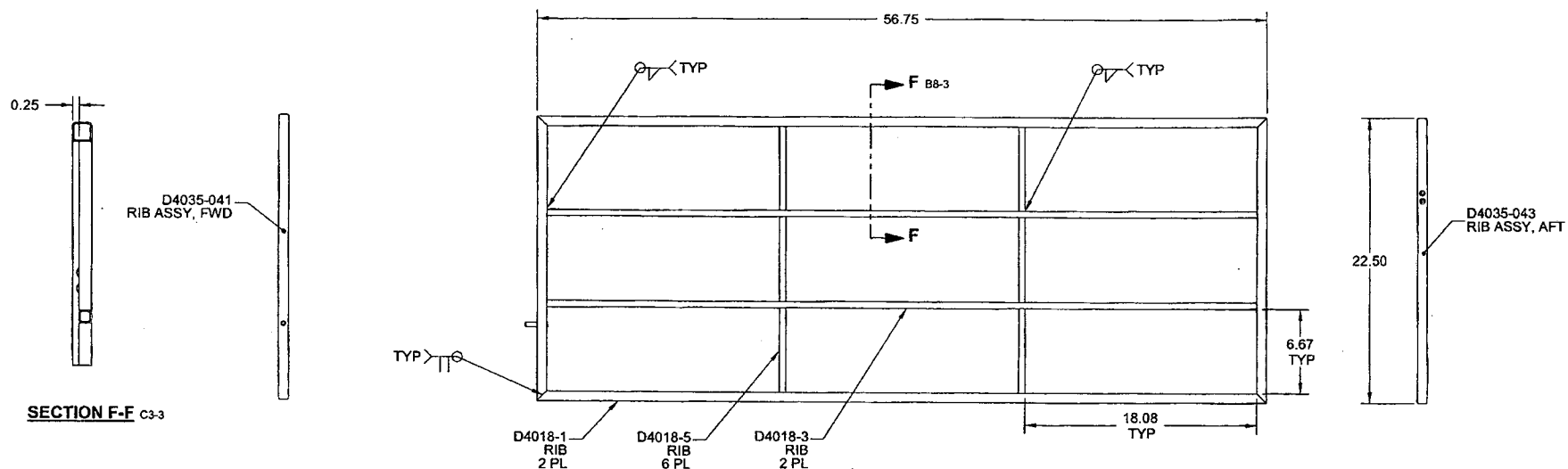
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	LS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	MS	D4018	SHEET 3 OF 4
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	SHORT BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

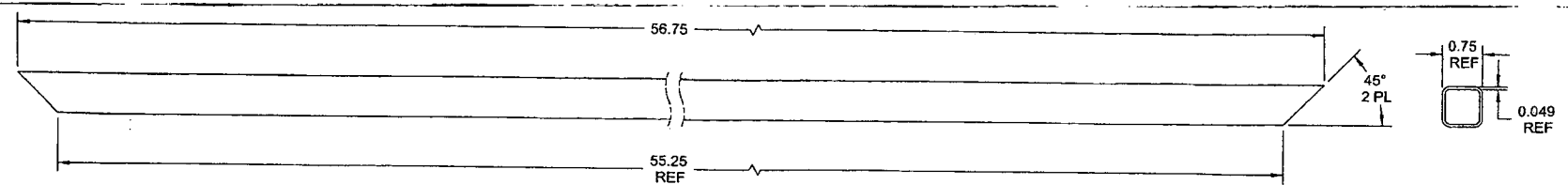
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

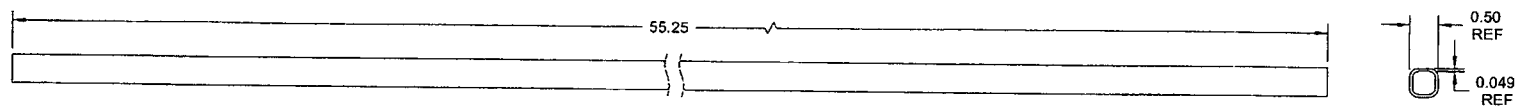
D



D4018-1 RIB

C

C



D4018-3 RIB

B

B



D4018-5 RIB

72436

RELEASED
10.08.12

- NOTES:**
- 1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
 - 3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: SEE ASSEMBLED WEIGHTS

A

A

DESIGN	A15	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ISC	DRAWING NO. D4018	REV. C
MFG. APPR.	h	SHEET 4 OF 4	
APPROVED	h	TITLE	SCALE
DE APPR.	h	SHORT BASKET LID ASSY (350)	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries